

Date: Wednesday, 03/06/2009 10:50:49 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HARD POINT KIT
Job Number : 48371	
Estimate Number : 11116	
P.O. Number :	Part Number : D407649011
This Issue : 03/06/2009 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : N/A
Previous Run : 43946	Material :
Written By :	Due Date : 30/06/2009 Qty: 2 Um: Each
Checked & Approved By : <u>JLD 09.06.03</u>	
Comment : Est Rev:B 98.12.07 Changed location for step 2 DM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Handwritten: JLD 09/06/10

**Comment:** DOCUMENT CONTROL

Photocopy blue file D407-649 and type labels per QSI 014 CHG001

Handwritten: S

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D2713	Lug
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

PickPacking Kit

Qty	P/N	Description	Batch
④	D2713	Bracket	B36699

Handwritten: JLD 09/06/10 (X2)

4.0	D27551	Lug
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PickPacking Kit

Qty	P/N	Description	Batch
①	D2755-1	Bracket	17551

Handwritten: JLD 09/06/10 (X2)

5.0	D27552	Lug
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PickPacking Kit

Qty	P/N	Description	Batch
①	D2755-2	Bracket	B7552

Handwritten: JLD 09/06/10 (X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HARD POINT KIT

Job Number: 48371

Part Number: D407649011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2756

Inner Doubler



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

PickPacking Kit

Qty

P/N

Description

Batch

(6)

D2756

Doubler

9234

SS 09/09/10 (K2)

7.0

D2757

Outer Doubler



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

PickPacking Kit

Qty

P/N

Description

Batch

6

D2757

Doubler

9235

SS 09/09/10 (K2)

8.0

M7885241

Rivet



Comment: Qty.: 96.0000 Each(s)/Unit Total : 192.0000 Each(s)

PickPacking Kit

Qty

P/N

Description

Batch

96

M7885/2-4-1

Rivet

M101692

SS 09/09/09 (K2)

9.0

M7885342

Rivet



Comment: Qty.: 126.0000 Each(s)/Unit Total : 252.0000 Each(s)

PickPacking Kit

Qty

P/N

Description

Batch

126

M7885/3-4-2

Rivet

M110267x65
M101840x78
M599 x109

SS 09/09/09 (K2)

10.0

AN46A

Bolt



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

PickPacking Kit

Qty

P/N

Description

Batch

24

AN4-6A

Bolt

M110399

SS 09/09/09 (K2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation: Description :

11.0 AN960JD416 Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total: 48.0000 Each(s)

PickPacking Kit

Qty P/N Description Batch
24 AN960JD416 Washer

M111279

SS 09/06/09 (12)

12.0 80007154A



M112086 33 48
M112086 33 48



Comment: Qty.: 24.0000 Each(s)/Unit Total: 48.0000 Each(s)

PickPacking Kit

Qty P/N Description Batch
24 80-007-15-4A Insert

M167003 x15 omit due to color.

SS 09/06/09 (12)

13.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/06/09 (12)

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D407-649-011

Location: 20

PPP Rev: C

06/19

15.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/19

Job Completion



MF
09-06-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries